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D350-636-012
Job Sheet 176616



Part No: D350-636-012

Job Qty: 1 ea

Part Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/26/18

Job Tracking No:

Due Date: 5/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3492 REV E SHEET 1, D2750-042 REV G SHEETS 1,2,5,9 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Ver:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD ver:EC IPP Rev:P 10.06.22 revise seq110 DD ver:EC IPP Rev:Q 10.10.01 as per IIN revH DDver:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/21/18	0.00	0.00	Start Up Skidtubes-1		DD
110	Skidtubes	1 pcs		5/21/18	0.00	4.36	Skidtubes-4		DD, BG
120	QC	1 pcs		5/21/18	0.00	0.00	QC10		DD 13.06.27
130	QC	1 pcs		5/21/18	0.00	0.00	QC5		DD 13.06.27
140	HandFinish	1 pcs		5/21/18	0.00	0.91	HandFinish1		SA 18-07-04
150	QC	1 pcs		5/21/18	0.00	0.00	QC7-2		DP2 18-07-05
160	Skidtubes	1 pcs		5/21/18	0.00	4.36	Skidtubes-1		BB DAS 38 9-89 38 9-89
170	QC	1 pcs		5/21/18	0.00	0.00	QC10		
180	QC	1 pcs		5/21/18	0.00	0.00	QC5		
190	HandFinish	1 pcs		5/21/18	0.00	0.91	HandFinish2		SA 18-07-18
200	SprayPaint	1 pcs		5/21/18	0.00	0.69	Spray Paint		AB JUL 20 2018
205	Outsource	1 pcs		5/21/18			ATE003-VC		N R
210	QC	1 pcs		5/21/18	0.00	0.00	QC14		SL 18-7-21
230	HandFinish	1 pcs		5/21/18	0.00	0.91	HandFinish4		SL 18-7-21
240	QC	1 pcs		5/21/18	0.00	0.00	QC5		38
250	Packaging	1 pcs		5/21/18	0.00	0.00	Packaging1-3		JUL 27 2018
260	QC	1 pcs		5/21/18	0.00	0.00	QC4		JUL 27 2018
265	DC	1 pcs		5/21/18	0.00	0.00	DC		DAS JUL 27 2018
270	Packaging	1 pcs		5/21/18	0.00	0.00	Packaging3-1		JUL 27 2018
280	QC21-FG	1 Ea		5/21/18	0.00	0.00	QC21		2188 JUL 27 2018

Part Op 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using Drill Jig DT8150 & Descriptions: DT8863A for second side only DT8863B for first side (detail K) 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750 A/R 138834
160 - 1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float holes using uni-bit to .500" (4 per Side) 4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: exp. date: **ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)** 8- Weld spacers D3490-1, D3490-3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermofforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																	
Date: _____ Step #: _____		QTY Effective: _____		MRB (QS1042) Approval																																																	
Description Work Order Deviation				Disposition																																																	
Root Cause <table border="1"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> DART AEROSPACE Container No: S080884 Part: D350-636-012 Job No: 176616 Serial No/Batch: S080884 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 06/13/18				Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																																																					

and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: 138834 9- At section AP-AP drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5084461 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 138886

210 - Inspect for foreign object per QSI 024

230 - 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: M138783 EXP DATE: 18112

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M1388213 5-Coat all exposed fasteners with "LPS Procyon" batch: M133646

265 - record fwd angle: 89.7 Photocopy blue file and type labels per PPP D350-636-012 CHG 007

270 - Package as per PPP D350-636-012

Job BOM

004634

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 Ea (1 ea)	90-Start up Operation	5073308
D2744	Cap	1 Ea (1 ea)	110-Skidtubes	5063692
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5079760
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5082661
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5065863
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5066254
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	5058138
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	5057153
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5076000
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5006333-1
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	FM137203
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5091818
D3488-042	Blade Fitting RH	1 Ea (1 ea)	230-HandFinish	5070890
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	5077552
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	5091848
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	5080560
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	5081731
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	5083401
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	5038407
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	5071379
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	5089345
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	5089448
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	5071975
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	5081738
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5083545
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5050046-1
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	5066493
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	M138409-121
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5036714
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	5049430
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	5077839
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	F137162
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	5068565
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	5095455
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	5090421
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5050646
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	F125635

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-RH	1	1	0
110-Skidtubes	D2744	1	87	0
160-Skidtubes	D2739	1	16	0
	D2743	8	134	0
	D3490-1	4	28	0
	D3490-3	4	11	0

230-HandFinish	ALS4-1032-225	38	5,580	0
	AN3C5A	34	1,993	0
	AN3C6A	4	286	0
	AN6C44A	4	363	0
	AN8C35A	1	52	0
	D2745	8	137	0
	D3488-042	1	0	0
	D3492-1	8	120	0
	D3492-3	8	45	0
	D3535-25	1	27	0
	D3536-25	1	35	0
	D3537-1	3	126	0
	D3631-1	8	955	0
	D3791-1	1	23	0
	D3793-1	1	11	0
	D3793-3	1	19	0
	D3794-1	1	24	0
	D3794-3	1	32	0
	MS21043-6	4	212	0
	MS21083C8	1	137	0
	NAS1149C0332R	38	6,209	0
	NAS1149C0832R	1	73	0
	NAS1515H3L	4	211	0
	NAS1611-010	8	601	0
	NAS1611-013	8	397	0
250-Packaging	AN8C21A	2	107	0
	D2741	1	54	0
	D3493-1	2	34	0
	D3532-1	2	46	0
	MS21083C8	2	137	0
	NAS1149D0863J	2	125	0

Part Specifications

Specifications could not be found.